

Work Order ID 74076

Wednesday, September 21, 2011 10:34:38 A



Page 1

Item ID: D4155-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10/9/21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4155

B

100

0.00



Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 91.75"

11/10/17

6

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

1-Mill as per folio FB048 & dwg D4155,

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

11/10/17

6

Manual Mill

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74076



Page 2

Wednesday, September 21, 2011 10:34:39 A

Item ID: D4155-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

11/10/18

6

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/11/18

(46)

Quality Control

140

0.00



Small Fab

Memo

0.00

11/10/18

6

Small Fab

Grind off chamfer on fwd end of bar as per dwg

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Work Order ID 74076

Wednesday, September 21, 2011 10:34:39 A

Page 3

Item ID:	D4155-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Bar				Stop	
Start Date:	9/21/2011	Start Qty: 6.00		Cust Item ID:		
Required Date:	9/30/2011	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
160  Packaging Packaging	Identify as per dwg & Stock Location <i>W/A</i> Memo	0.00 0.00							<i>10/11/10/18</i>
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/10/18</i> 

MR
11-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 10:34:44 AM

Page 1

Work Order ID: 74076

Parent Item: D4155-1

Parent Item Name: Bar



Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	205.3147	7.6333	48.21032			
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

MAT006

109.3

116148

78

117842

31.3

MAT050

96.0147

117176

96.0147

119159

48.5 ~~90~~ 11/10/17

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

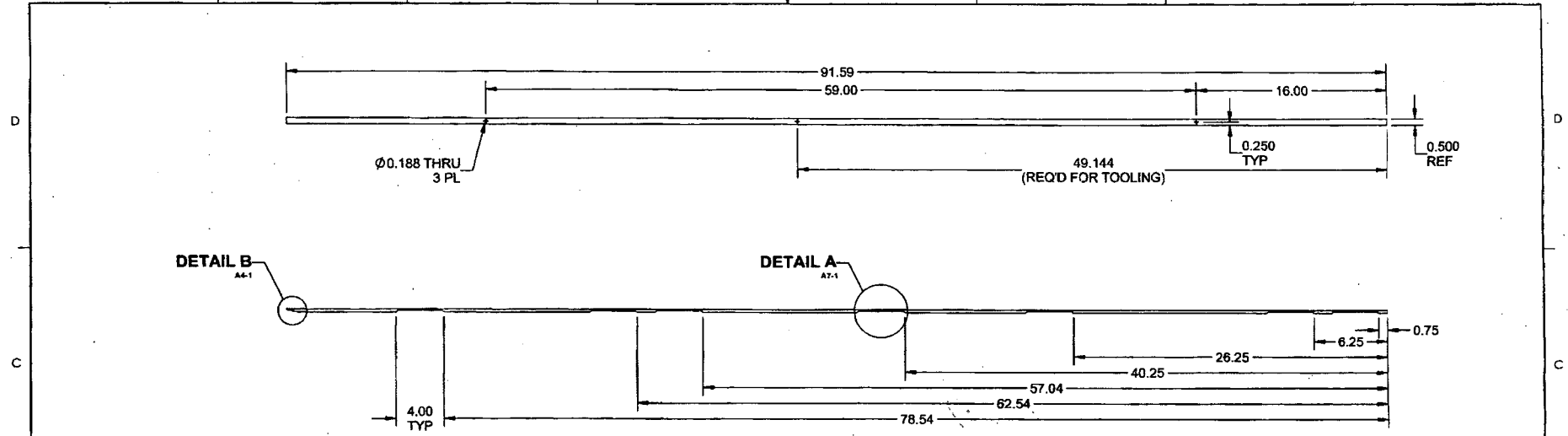
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

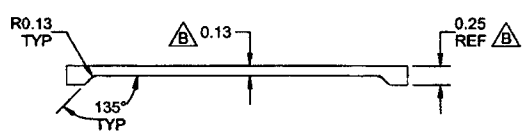
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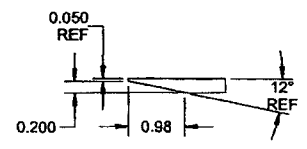
8 7 6 5 4 3 2 1



D4155-1 BAR



DETAIL A
D4-1
SCALE 2X, TYP



DETAIL B
A7-1
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 741024

RELEASED
R 2011-04-13

11-09-21

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X00.500
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.82 lbs

B	CHANGED MANUFACTURING PROCESS; MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	11.04.05		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D4155**

TITLE **BAR**

REV. B
SHEET 1 OF 1
SCALE
NTS

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Dart Aerospace Ltd

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